| Work Order ID June-12-13 9:13:53 AM | , | 2775 | | *10: | 2775* | | | | | | Page 1 |
|---|-----|------------------------------------|-------------------------------------|----------------------|--------------------------|------------|--------------|---------------|-----------------|------------------|----------------|
| Item ID: D3245- Revision ID: Item Name: Door | 5 | | | Accept | *N900 | 040 | 100 |)* s | etup Sta Sto | 1.7 | S1* S2* |
| Start Date: 6/11/13 Required Date: 6/11/13 Reference: | , | Start Qty: 8.00 Req'd Qty: 8.00 | *8* *8* | | Cust Item I Customer: | D: | | | | IN | 3/ |
| Approvals: Proces | , | n: ML5 | Date: \(\frac{1}{3} - 0(0^{-1}) \) | | | ate: | | R | un Sta Sto | | R1* R2* |
| Sequence ID/ Work Center ID | | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| Draw Nbr | Rev | ision Nbr | | | • | | | | | | |
| D3245 | D | | | | | | | | | | |
| *100* | 1 | FLOW WATER JET | | 0.00 | | | | -8 | | | Au |
| Waterjet FLOW CNC Waterjet | | Memo | r Dwg D3245 | 0.00 | | | | | | | 13.07 |
| 304 .032 | ' | Dwg Rev:_ Prog Rev:_ 2-Deburr if | D | | | | | | | | |
| 110 | | QC2- Inspect parts off m | nachine FAI/FAIB | 0.00 | | | | | | | 1 |
| *110* QC | | Memo | | 0.00 | | | | ~ | | | 13.07.1 |

Quality Control

| DQA: | | _ Date: | | | | | | | | | | • | ^L AART |
|----------------------|----------|--------------|-------------|-------|--------------------------------|-----|-----------------------|----------------------------|------------|---------------|---------------------------------------|----------|--------------------|
| QA Closed: | | Date: | | | WORK ORDER NON- | -CC | ONFO | RMANCE / UPDATE | w | ork Order up | odate only | _ | AEROSPAÇE |
| | | | | | DISPOSITION | | | AGAINS | T DE | PARTMENT | /PROCESS | | |
| Work Orde | er: | | | | | , | | | _ | , 1 | _ | _ | |
| | | | | | Rework | | | Skid-tube Crosstub | _ | _ | Water Jet | _ | Engineering |
| Part N | 10 | | | | Scrap | | | Machining Small Fal | — | -1 | d. Eng. Coor. | _ | Quality |
| NCR N | lo | | | | Use-as-is Suspected Unapproved | | inern | noforming Finishin | _ | Rec/Stoi | re/Packaging | | Other |
| NCK I | | | | | Suspected Onapproved | J | | Large Fab Composite | <u>- ا</u> |] | Supplier | | |
| Root | | | | Desci | ription of work order update | | nitial | Action | | Sign & | | T | |
| Cause | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Description | | Date | Verification | 1 | QC Inspector |
| Design | | | | | · | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | |
| Equip/Tooling | _ | | | | | | | | | | | | |
| Handling/Pre | _ | | | | | | | | | | | | |
| Material | _ | | | | | | | | | | | | |
| Operator | _ | | | | | | | | | | | | |
| Offset/Setup | \vdash | | | | | | | · | | | | | |
| Process | | : | | | | | | | | | | İ | |
| Supplier | \vdash | | | | | 1 | | | | | | ı | |
| Training | | | | | | 1 | | | | | | 1 | |
| Transport Unapproved | | | | | | | | | | 1 | | | |
| Onapproveu | | | | l | | ΕΛΙ | IIIT CA | L TEGORY | | <u> </u> | L | | |
| Landi | ng Gear | | | | General | 17 | OLI CA | ILOOKI | | | | | |
| 20.10.1 | Bendin | , | | | Bend | | l _{Folio} /F | Program | Г | Outside Dim | ensions [| | Pressure/Forced |
| | | Not Conce | ntric | | BOM/Route | H | Grain | | \vdash | Over/Under | ŀ | — | Set-up |
| | Cracks | | | | Broken/Damage/Defect | | Hardwa | are | | Part Incorred | | _ | Temperature/Cure |
| | | Kink/Ripple | e/Wave | | Burrs | Т | ł | ion Incomplete/Unqualified | | Part Lost/Mi | + | \dashv | Weld |
| | Cuffs | | | | Contamination | | 1 | tions Incomplete/Unclear | | Part Moved | | | Wrong Stock Pulled |
| | Crushir | g | | | Countersink | | 1 | gned/off center | | Positioned V | ւ Vrong | | |
| | Heat Tr | | | | Cut Too Short | | Mislabe | | | Power Loss/ | - r | | Other |
| | Inspect | ion Strip in | Tube | | Drawing | | Misrea | d | | - | - L | | |
| | Marks/ | Chatter | | | Drill Holes | | Off-set | | | | · · · · · · · · · · · · · · · · · · · | | |
| | Turning | sequence | ! | | Finish | | Out of | Calibration | | | | | |
| | Waye/ | Ewist in Tul | he | | Fit/Function | | Out of | Seguence | | | · | | |

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

| DQA: | Date: | | | | | - wark apper you consorrance (uppare | | | | | | | |
|---------------|--------------------|-----------|-----------|-------|--------------|---|----------|--------------------|----------------------------|---------|----------------|---------------------------------------|--------------------|
| QA Closed: | | | Date: | | | WORK ORDER NON- | -CC | ONFO | RMANCE / UPDATE | \٨/ | ork Order up | odate only | AEROSPAÇE |
| QA Closed. | | | Date. | | | | _ | | - | | | · · · · · · · · · · · · · · · · · · · | 1 |
| Work Orde | er: | | | | | DISPOSITION | | | AGAINS | T DE | PARTMENT | PROCESS | |
| | - | | | | _ | Rework | | | Skid-tube Crosstub | e |] | Water Jet | Engineering |
| Part N | No. | | | | | Scrap | | | Machining Small Fa | ь | Pro | d. Eng. Coor. | Quality |
| | | | | | | Use-as-is | | Thern | noforming Finishin | g | Rec/Stor | e/Packaging | Other |
| NCR I | ۱o | | | | | Suspected Unapproved | | | Large Fab Composit | :e |] | Supplier |] [] |
| Post | - | | 1 | Г | Docc | rintian of work order undate | | nitial | Action | | Sign 9 | | 1 |
| Root Cause | | Date | Step | Qty | Desci | ription of work order update or non-conformance | | nitial iief Eng | i | | Sign & Date | Verification | QC Inspector |
| Design | \vdash | Date | Step | Qty | | of floir-comormance | Cii | ilei, ciig | Description | | Date | Vermeation | QC IIIspector |
| Doc/Data | Н | | | | | | | | | | | | |
| Equip/Tooling | Н | | ,i | | | | | | | | | | |
| Handling/Pre | П | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | |
| Operator | | - | | | | | • | * • | | | | | |
| Offset/Setup | П | | | | | | - | | | | | | |
| Process | | | | | | | | • | | | | | |
| Supplier | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | |
| Transport | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | |
| | | | | | | | FAL | ULT CA | TEGORY | | | | |
| Landi | ng G | ear | | | | General | | • | | | _ | | |
| | \square | Bending | | | | Bend | <u> </u> | Folio/F | Program | L | Outside Dim | ensions | Pressure/Forced |
| | LJ' | Centre No | ot Concer | ntric | <u> </u> | BOM/Route | _ | Grain | | L | Over/Under | tolerance | Set-up |
| | ⊢⊣ | Cracks | | | _ | Broken/Damage/Defect | | Hardwa | | L | Part Incorred | ct | Temperature/Cure |
| | - | Crimp/Kir | nk/Ripple | /Wave | _ | Burrs | | Inspect | ion Incomplete/Unqualified | L | Part Lost/Mi | ssing | Weld |
| | - | Cuffs | | | _ | Contamination | | 4 | tions Incomplete/Unclear | \perp | Part Moved | L | Wrong Stock Pulled |
| | - | Crushing | | | | Countersink | | 1 ' | gned/off center | L | Positioned V | | |
| | \vdash | Heat Trea | | | \perp | Cut Too Short | L_ | Mislabe | | L | Power Loss/ | Surge | Other |
| | \vdash | Inspectio | | Tube | | Drawing | | Misrea | | | | | |
| | \vdash | Marks/Ch | | | | Drill Holes | _ | Off-set | | | | | |
| | - | Turning S | - | | | Finish | | 4 | Calibration | | | | |
| | Wave/Twist in Tube | | | | Fit/Function | 1 | Out of | Sequence | | | | | |

| Work Ord June-12-13 9: | | 02775 | | *102 | 775* | | | | | | Page 3 |
|---|-----------------------|---|-------------------------|------------------------------|--------------------------|------------|--------------|---------------|--------------------|------------------|----------------|
| Item ID: Revision ID: Item Name: | D3245-5 Door | τ | | Accept | *N900 | 040 | 100 |)* 5 | Setup Star Stop | 1 7 | S1* S2* |
| Start Date: Required Dat Reference: | 6/11/13 e: 6/11/13 | Start Qty: 8.00 Req'd Qty: 8.00 | *8* *8* | | Cust Item I Customer: | D: | _ | | S4 | | |
| Approvals: | Process P | lan: | Date: | Tooling: | Da | ate: | | | Run Star | 17 | R1* |
| • • | QC: | | Date: | SPC (Y/N): | Da | ate: | | | Sto | ` *N | R2* |
| Sequence ID/ Work Center | | Operation Description Identify as per dwg & S | ock Location: <u>GA</u> | Set Up/ Run Hours 0.00 | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| *150* Packaging Packaging | | Мето | | 0.00 | • | | | 7 | | | 13 |
| 160 *4.CO* | | QC21- Final Inspection | - Work Order Release | 0.00 | | | | | → 1 | 2 2- | -77~ |
| *160* | | Memo | | 0.00 | | | | M | (ブー) | 2-01 | |

Quality Control

MLJ 13-07-22 MLJ 13-07-22

| DQA: | | | Date: | | | | | | | | | | | |
|---------------|-------------------------------------|-----------|------------|--------------|------|-----------------------------------|----------|----------|---------------------|------------------------|----|------------------------------|---------------------------------------|--|
| QA Closed: | | | Date: | | | WORK ORDER NON- | -CC | ONFO | RMANCE / U | | Wo | ork Order up | odate only | AEROSPAÇE |
| | | | | | | DISPOSITION | | | | | | PARTMENT | · · · · · · · · · · · · · · · · · · · | |
| Work Orde | er: | | | | | | | | | г | | • | | , , , , , , , , , , , , , , , , , , |
| Part N | lo. | | | | | Rework Scrap | | Į. | Skid-tube Machining | Crosstube Small Fab | | | Water Jet d. Eng. Coor. | Engineering Quality Other |
| NCR N | 10. | | | | | Use-as-is Suspected Unapproved | | mem | noforming Large Fab | Finishing Composite | | Rec/Store/Packaging Supplier | | - Other |
| Root | | | | | Desc | ription of work order update | | nitial | Action | | | Sign & | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Desc | ription | | Date | Verification | QC Inspector |
| Design | | . — . — | | | | ` | | | | • | | | | |
| Doc/Data | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | l | | | | ľ | | | , |
| Handling/Pre | | | | | | | | | | | İ | | | |
| Material | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | |
| Supplier | | | | | | 1 | ł | | | | | | | |
| Training | | | | | | | | | | | | | | |
| Transport | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | |
| | | | | | | | FA | ULT CA | regory | | | | | |
| Landii | ng G | Gear | | | | General | | | | | | | | |
| | | Bending | | | | Bend | | Folio/F | rogram | | | Outside Dim | ensions | Pressure/Forced |
| | | Centre No | ot Concer | ntric | | BOM/Route | | Grain | | | | Over/Under | tolerance | Set-up |
| | | Cracks | | | | Broken/Damage/Defect | | Hardwa | ire | ĺ | | Part Incorred | ct | Temperature/Cure |
| | | Crimp/Kir | nk/Ripple | /Wave | | Burrs | | Inspect | ion Incomplete/U | nqualified | | Part Lost/Mi | ssing | Weld |
| | | Cuffs | | | | Contamination | Г | Instruct | ions Incomplete/ | Unclear | | Part Moved | | Wrong Stock Pulled |
| • | | Crushing | | | | Countersink | | Misalig | ned/off center | İ | | Positioned V | Vrong | |
| | | Heat Trea | at | | | Cut Too Short | | Mislabe | | | - | Power Loss/ | | Other |
| | | Inspectio | n Strip in | Tube | | Drawing | | Misrea | d | • | | | - | • |
| | | Marks/Ch | natter | | | Drill Holes | | Off-set | | | • | | · | |
| | | Turning S | equence | | | Finish | | Out of | Calibration | | • | | | |
| | Turning Sequence Wave/Twist in Tube | | | Fit/Function | | Out of | Sequence | | | | | | | |

June-12-13 9:13:52 AM

Work Order ID:

102775 i

Parent Item:

D3245-5

Parent Item Name:

Door

Start Date: 6/11/13

Required Date: 6/11/13

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP A'04.07.07New issueKJ/JLM

IPP Rev:b ECN 1052 07-10-31 DD verified by:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|--------------------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S22GA 304/316 .032 Sheet | ì | Purchased | No | | | 100 | sf | 172.4800 | 0.07 | 0.5894736 | Re | | .59 |
| | i | | | Location MAT020 | | <u>Loc Otv</u> 172.48 | Lo | c Code | | | (| 13.0 | 7.19 |
| 19 | I | | | 1182 1208 | | 10.76 55.47 | | | | | | | |
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| DQA: | Date: | | | | | MODIL ODDED MON | | | SAAAIGE / LIDDATE | | | | \7 \7 | |
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| QA Closed: | | | Date: | | | WORK ORDER NON- | -C(| JNFOI | RMANCE / UPDATE | W | ork Order up | date only | 7 | AEROSPAÇE |
| Manda Onda | | | | | | DISPOSITION | | | AGAINST | DE | PARTMENT | PROCESS | | |
| Work Orde | er: - | | | | | 0 | | | ماريد ايزاري | _ | 1 | Mater let | | |
| Dort N | ١٥ | | | | | Rework | | l . | Skid-tube Crosstube Machining Small Fab | | | | - Engi | ineering Quality |
| Part N | ··· - | | | | — | Scrap Use-as-is | | | noforming Finishing | - | 4 | re/Packaging | - | Other |
| NCR N | lo | | | | | Suspected Unapproved | | | Large Fab Composite | · | 1 1100 | Supplier | | |
| | | | | | | | | | | Autim Cim 9 | | | | |
| Root | | _ | _ | | Desci | ription of work order update | | nitial | Action | | Sign & | | | |
| Cause | \dashv | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Description | | Date | Verification | Q | C Inspector |
| Design | _ | | | 1 | | | | | | | | | | R |
| Doc/Data | | | | | | | | | | |] | | 1 | |
| Equip/Tooling | \dashv | | | | | | i | | | | | | | • |
| Handling/Pre | \dashv | | | | | | | | | | | | | |
| Material | \dashv | | | | | | | | | | | | | |
| Operator Offset/Setup | \dashv | | | | | | | | | | | | | |
| Process | \dashv | · | , , | | | | | | | | | | | |
| Supplier | \dashv | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | - |
| Transport | | | | | | · | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | |
| ``` | | | | | | | FAI | ULT CAT | TEGORY | | | <u> </u> | <u> </u> | |
| Landi | ng G | iear | | | | General | | | | | | | | |
| | | Bending | | | | Bend | | Folio/F | Program | | Outside Dim | ensions | Pressu | re/Forced |
| | | Centre No | t Concer | ntric | | BOM/Route | | Grain | | | Over/Under | tolerance | Set-u | р |
| a de la companya de la companya de la companya de la companya de la companya de la companya de la companya de | | Cracks | | | | Broken/Damage/Defect | | Hardwa | are | | Part Incorred | ct | Temp | erature/Cure |
| | | Crimp/Kin | k/Ripple | /Wave | | Burrs | | Inspect | ion Incomplete/Unqualified | | Part Lost/Mi | ssing | Weld | |
| | | Cuffs | | | | Contamination | | Instruct | tions Incomplete/Unclear | | Part Moved | | Wron | g Stock Pulled |
| | | Crushing | | | | Countersink | | Misalig | gned/off center | | Positioned V | Vrong _ | | |
| | | Heat Trea | t | | | Cut Too Short | | Mislabe | eled | | Power Loss/ | Surge | Other | |
| | | Inspection | n Strip in | Tube | | Drawing | | Misread | d | | | | | |
| | | Marks/Ch | atter | | | Drill Holes | | Off-set | | | | | | |
| | - | Turning S | | | | Finish | | Out of | Calibration | | | | | |
| | Wave/Twist in Tube | | | | Fit/Function | | Out of | Sequence | | | | | | |

| DART AEROSPACE LTD | Work Order: | 102775 |
|------------------------------|----------------|-------------|
| Description: Angle Plate | / Part Number: | D3245-5 |
| - | | |
| Inspection Dwg: D3245 Rev: Ø | 120.15 | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| 0.200 +/-0.010 ,200 - | Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|--|----------------------|---------------|---------------------|--------|--------|-------------------------|----------|
| 0.194 +/-0.010 .194 - ✓ 1.062 +/-0.010 1.064 - ✓ 1.150 +/-0.005 1.150 - ✓ 1.000 +/-0.010 1.000 - ✓ 6.000 +/-0.010 6.000 - ✓ 8.69 +/-0.030 8.68 - ✓ ω)-02 | 0.200 | +/-0.010 | ,200 | | | V | JKm-01 |
| 1.062 +/-0.010 1.064 - V 1.150 +/-0.005 1.150 - V 1.000 +/-0.010 1.000 - V 6.000 +/-0.010 6.000 - V 8.69 +/-0.030 8.68 - V wJ-02 | 0.194 | +/-0.010 | | - | | | |
| 1.150 | 1.062 | +/-0.010 | | _ | | | |
| 1.000 +/-0.010 1.000 - V 6.000 +/-0.010 6.000 - V 8.69 +/-0.030 8.68 - V WJ-02 | 1.150 | +/-0.005 | | _ | | V | |
| 6.000 +/-0.010 6.000 - V 8.69 +/-0.030 8.68 - V WJ-02 | 1.000 | +/-0.010 | 1 ' ' | _ | | | |
| 8.69 +/-0.030 8.68 - V wJ-02 | 6.000 | +/-0.010 | | | | | |
| | 8.69 | +/-0.030 | | _ | | | WJ-02 |
| | Ø0.108 | +0.005/-0.001 | | ~ | | | |
| | | | | | | | |

| Measured by: | Ae | Audited by: | \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ | Preliminary Approval: | |
|--------------|----------|-------------|--|-----------------------|--|
| Date: | 13.07.19 | Date: | B710 | Date: | |

| Rev | Date | Change / * | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| Α | 08.09.04 | New Issue | KJ/DD 👝 | 2/ |
| В | 12.05.14 | Dimensions updated per Dwg Rev C | KJ 👯 | |
| | | | | |

